



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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✓ D2666-1

Job Sheet 196973



Part No: D2666-1

Job Qty: 4 pcs ✓

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/26/19

Job Tracking No:

Due Date: 7/15/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	7/15/19		0.00	3.66	HAAS - 1		1/15 19/7/5
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	7/15/19		0.00	4.49	Conventional Mill - 1 - B4B		SB2 19/07/06
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	7/15/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S196180



Part: D2666-1

Job No: 196973

Serial No/Batch: S196180

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 07/05/19

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130 QC 8	4 pcs	7/15/19	0.00 0.00	QC 2 - 57	SBC
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	7/15/19	0.00 0.21	QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mm L 19/07/09
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUL 09 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)-	4	7/15/19	0.00 0.18	Powdercoat - 1 - B4B	19.7.9

START: 2:10

O.V. 300 FINISH 2:40

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B4B		pcs			Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	4 pcs	7/15/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	7/15/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	

DAS
81
9-89

JUL 10 2019



0.2

Bin: ST 402

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	7/15/19	0.00 0.00	QC 21 - SA - 21	JUL 16 2019 DAS 70 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - HAAS CNC Vertical Machine - Program batch number. Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5184644	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	4	37	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD				Work Order: 196073	
Description: 206 Saddle, Inboard, Left side				Part Number: D2666-1	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.1195	0.120	0.120	0.120	
B	0.100	0.140		0.130	0.130	0.130	0.130	
C	2.470	2.510		2.496	2.496	2.494	2.494	
D	0.100	0.180		0.135	0.135	0.133	0.133	
E	0.210	0.230		0.220	0.220	0.220	0.220	
F	1.313	1.343		1.322	1.322	1.322	1.322	
G	0.240	0.260		0.249	0.250	0.250	0.250	
H	0.615	0.685		0.650	0.650	0.650	0.650	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.004	1.004	1.004	1.004	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.510	0.515		0.510	0.510	0.510	0.510	
M	0.100	0.120		0.115	0.115	0.115	0.115	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		5.995	5.996	5.996	5.996	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		0.498	0.501	0.498	0.500	
S	0.312	0.318		0.325	0.312	0.312	0.312	
T	2.495	2.505		2.499	2.499	2.500	2.500	
U	1.357	1.367		1.363	1.363	1.363	1.363	
V	0.315	0.322		0.316	0.316	0.316	0.316	
W	0.540	0.560		0.542	0.546	0.546	0.546	
X	1.674	1.684		1.680	1.680	1.680	1.680	
Y	0.256	0.262		0.257	0.257	0.257	0.258	
Z	0.178	0.198		0.188	0.188	0.188	0.188	
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: VHS/SBL	Date: 19/7/15/14/6/200
Audited by: mmc	Date: 19/07/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	